

Work Order ID 149601

Monday, July 25, 2016 2:38:04 PM

647.0410
B 1 49601
REV. N/C

149601

Page 1

Item ID: 647.0410

Revision ID:

Item Name: Tube

Start Date: 7/4/2016 Start Qty: 5.00 *5*

Required Date: 7/25/2016 Req'd Qty: 5.00 *5*

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: DAS 21 9-89 Date: AUG 03 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

647.0400	N/C
----------	-----

110

0.00

110

Small Fab

Memo

0.12

Small Fab

1- CUT AS PER DWG
2- DEBURR AS PER DWG

5 FF

OCT 18 2016

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

5

DAS
38
9-89

OCT 20 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 149601

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Page 2

Item ID: 647.0410 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Tube
Start Date: 7/4/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 7/25/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : <u>34063</u> 1- Black Anodize as per Dwg 647.0400 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	0.00 149.99				<u>5</u>		OCT 26 2016	DAS 13 9-89
140 *140* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.02				<u>5x</u>		NOV 11 2016	DAS 26 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<u>(5)</u>			DAS 38 9-89 NOV 11 2016

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Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>CK107</u>	0.00							
180									
Packaging	Memo	0.01							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.08							
Quality Control									

DAS
6
9-89

NOV 14 2016

DAS
21
9-89

NOV 15 2016

DAS
21
9-89

NOV 14 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, July 25, 2016 2:38:04 PM

Page 1

Work Order ID: 149601

149601

Parent Item: 647.0410

647 0410

Parent Item Name: Tube

Start Date: 7/4/2016

Required Date: 7/25/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.09.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.035		Purchased	No			110	f	6.0300	0.4275	2.25			

M6061T6T1 000W 0.35

6061-T6 ROUND TUBE 1" X .035" WALL

FF OCT 18 2016

Location

Loc Qty

Loc Code

MAT015

6.03

124694

6.03

135489

2.25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
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Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
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Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

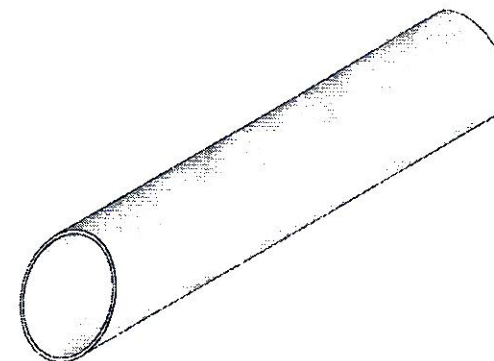
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: P01		N/C
2	WORK RELEASE	04/26/08	P. BRAYD

NOTES:

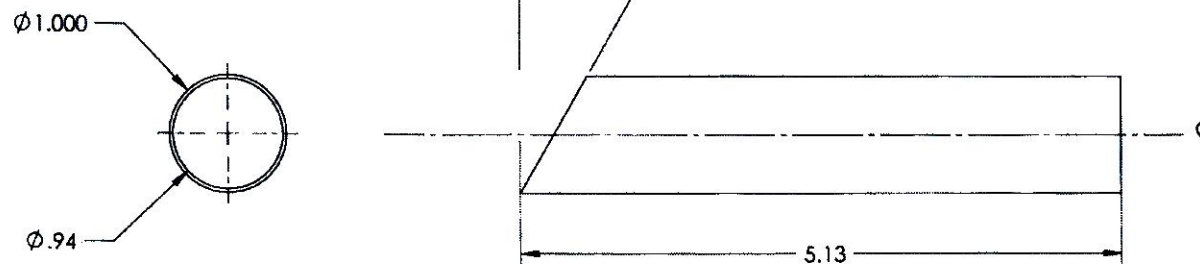
- 1 MATERIAL: 6061-T6 ALUMINUM IAW AMS-4080
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

179601 M.C.S
1608-03



647.0410



647.0410		TUBE		△	△
FIND #	PART #	DESCRIPTION	MATL	SPEC.	
PARTS LIST					
QTY	ORIGINAL DATE	REVISION	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		
NEXT ASSY (S)	APPROVED BY	DESIGNED BY			
646.9500	APPROVED BY	DESIGNED BY			
	APPROVED BY	DESIGNED BY			
TUBE					
IN CASE OVERSPECS SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .02 3 PLACE DECIMALS ± .005 ANGLES ± .5°			SCALE NONE	SHEET 1 OF 1	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34063**

Purchase Order Date 10/26/2016
PO Print Date 10/27/2016

Page Number 6 of 9

VC-ATG001

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone

613-446-4544

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

VENDOR'S TRUCK

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total:

\$70.50

15 151662

647.0210 RAIL REV. N/C

11/9/2016

Yes

11/9/2016

8.00

\$10.50

\$84.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total:

\$84.00

16 151660

647.0310 CHANNEL
REV. N/C

11/9/2016

Yes

11/9/2016

10.00

\$11.10

\$111.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total:

\$111.00

17 149601

DAS
38
9-89

647.0410 TUBE REV. N/C

11/9/2016

Yes

11/9/2016

5.00

\$8.65

\$43.20

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Note:

10/27/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912522

Date: 09-Nov-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
ea	Rail Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20322 PO: 34063	Line: 15	
10 ea	Part: 647.0310 Channel Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20323 PO: 34063	Rev: N/C Line: 16	
5 ea	Part: 647.0410 Tube Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20324 PO: 34063	Rev: N/C Line: 17	NOV 11 2016 DAS 26 9-89
12 ea	Part: 647.1716 Plate Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20325 PO: 34063	Rev: E Line: 18	
17 ea	Part: 647.1718 Gusset Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20326 PO: 34063	Rev: E Line: 19	
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 20329 PO: 34063	Rev: N/A Line: 23	
6	Part: 646.2910	Rev: N/C	



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912522

Date: 09-Nov-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via										
<table border="1"><thead><tr><th>Quantity</th><th>Description</th></tr></thead><tbody><tr><td></td><td>DATE : <u>9/11/16</u></td></tr><tr><td></td><td>CERTIFIED SIGNATURE : <u>DAS 28</u></td></tr><tr><td></td><td>RECEIVER SIGNATURE : <u>9-89</u> <u>NOV 11 2016</u></td></tr><tr><td colspan="2"> Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA. DAS 38 9-89 </td></tr></tbody></table>		Quantity	Description		DATE : <u>9/11/16</u>		CERTIFIED SIGNATURE : <u>DAS 28</u>		RECEIVER SIGNATURE : <u>9-89</u> <u>NOV 11 2016</u>	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA. DAS 38 9-89	
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